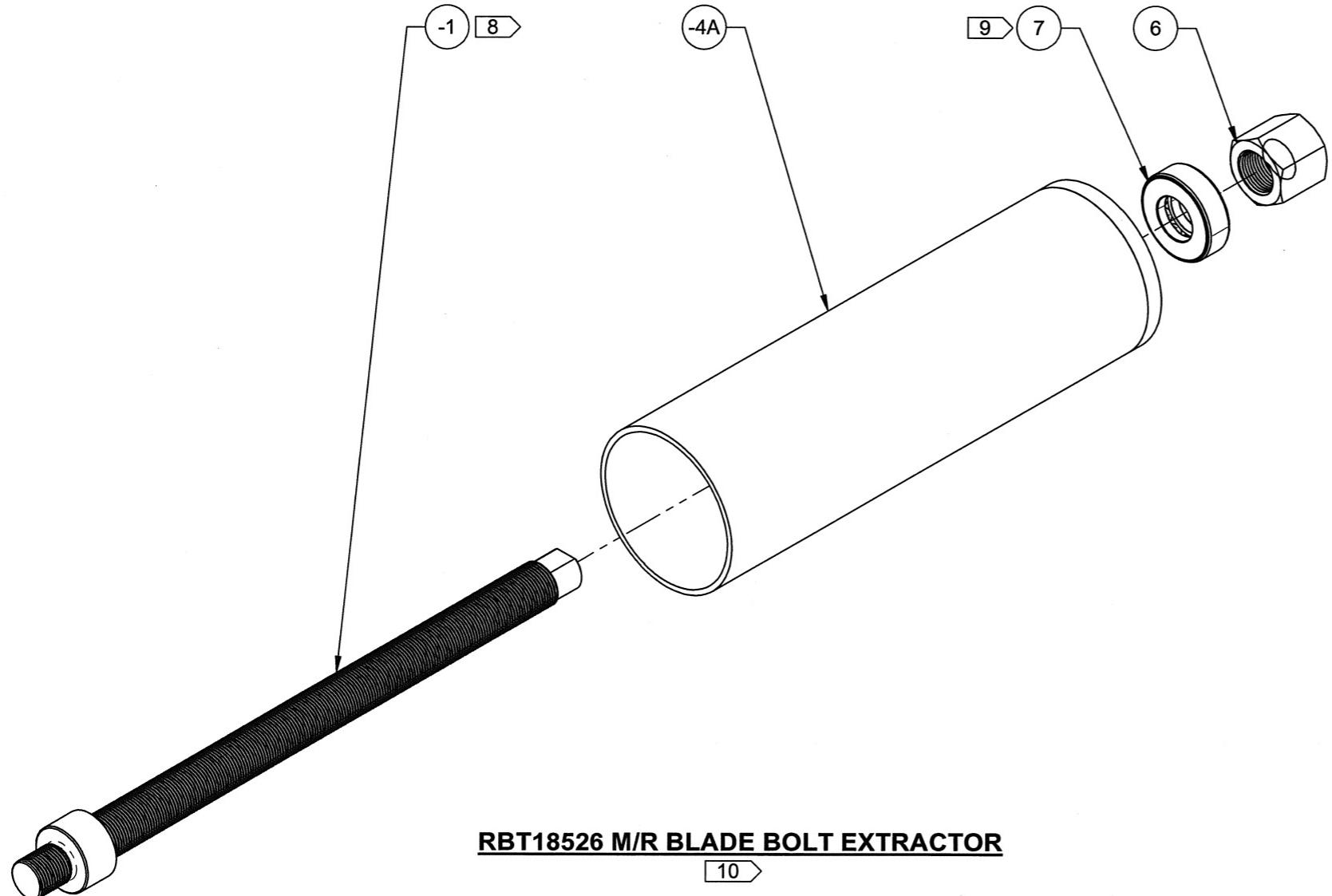


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ITEM #	QTY	PART #	PART TITLE
-1	1	RBT18526-1	THREADED PULLER ROD
-4A	1	RBT18526-4A	TUBE WELDMENT
6	1	McMaster#90565A350 OR EQUIV	STEEL GRADE 8 HIGH HEX NUT 1"-14 X 1-5/16 HEIGHT
7	1	GRAINGER #4ZZR3 OR EQUIV	STEEL BANDED BALL THRUST BEARING 1.000" I.D X 1.969" OD X 0.625 THK

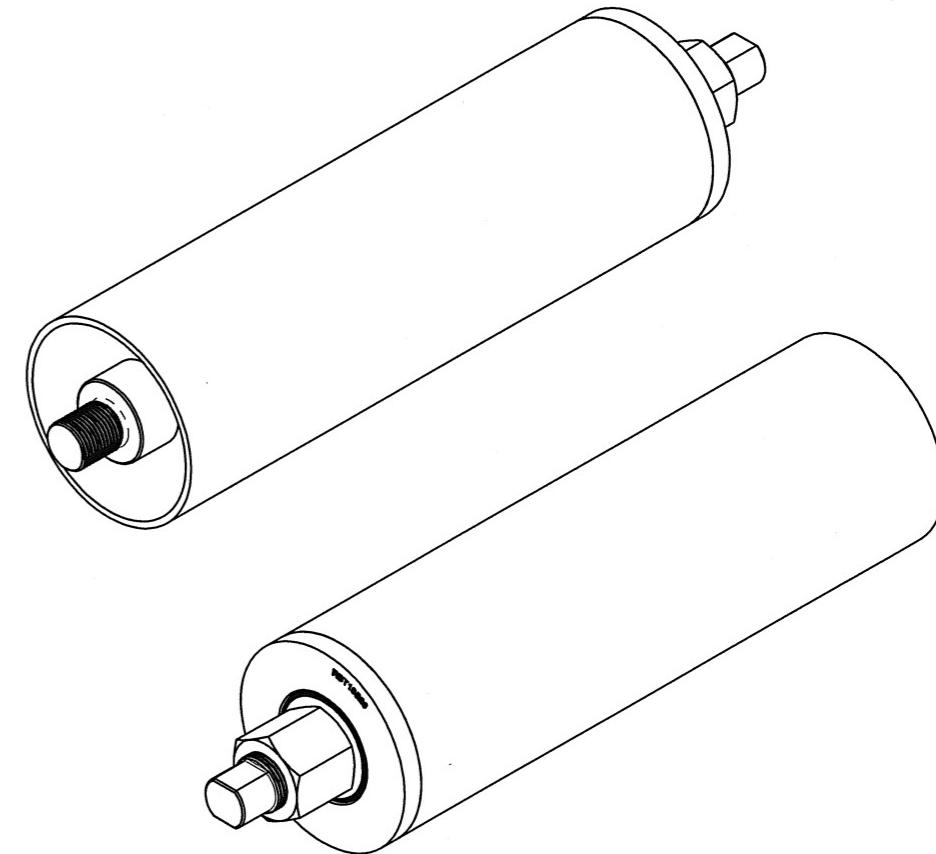
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- NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) IDENTIFICATION: N/A
 7) ASSEMBLE AS SHOWN
 8) APPLY GREASE MIL-PRF-23827 TYPE II ON THREADS OF ITEM -1
 9) PRESS FIT ITEM 7 WITH ITEM -4A
 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



FOR OLDER REVs SEE PREVIOUS PDFs TEMPLATE UPDATED PER DART HBY STANDARD ITEM -1A ASSY DELETED ITEM -2 McMaster#90565A350 CHANGED FOR ITEM 6 McMaster#90565A350 ITEM -1 WAS MADE OUT OF 2 PARTS NOW IS MANUFACTURE IN A SINGLE PART, MATERIAL McMaster#92580A153 CHANGED FOR 4140 (28-32 RC), NOTE FOR UNDERCUT REPLACED BY DIMENSIONS 0.09 2PL X Ø0.76 X R0.06 2 PL, UNDERCUT ADDED 0.09 2 PL X Ø0.88 X R0.06 2PL, DIMENSION Ø1.50 ADDED, DIMENSION 13.64 ADDED, DIMENSION 14.0 CHANGED FOR 15.50, DIMENSION 2X R.03 CHANGED FOR R.03 ALL AROUND EDGE, DIMENSION .75 CHANGED FOR 0.750, DIMENSION 2X .03 X 45° CHANGED FOR 0.03 X 45.0° CMF ALL AROUND EDGE ITEM -4A FINISH BLACK OXIDE CHANGED FOR ZINC YELLOW PLATE ITEM -4 MATERIAL 1018/1020 CR CHANGED FOR 4140 (28-32 RC), DIMENSION Ø1.9530/1.9520 V .31 CHANGED FOR Ø1.9689/1.9681 V 0.625 +0.005/-0, ENGRAVING ADDED, DIMENSION 0.06 X 45.0° CMF ADDED, DIMENSION Ø3.50 CHANGED FOR Ø3.45, DIMENSION R.008" MAX ADDED, DIMENSION R0.03 ADDED, DIMENSION 0.03 X 45.0° CMF ADDED, DIMENSION .63 CHANGED FOR 1.00, DIMENSION .38 REPLACED BY DIMENSION 0.62 ITEM -5 MATERIAL DOM CHANGED FOR A513 TYPE 5 DOM TUBING, DIMENSION 11.2 CHANGED FOR 11.87, ENGRAVING REMOVED			19-820	VM
REV.	DESCRIPTION		ECN #	BY
DESIGN	VM	DART AEROSPACE LTD		
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA		
CHECKED	KPT	REV C		
MFG. APPR.	FK	SHEET 1 OF 5		
APPROVED	WP	TOOL PART #		
RBT18526			TITLE	
M/R BLADE BOLT EXTRACTOR			SCALE	
NTS			E-3	
DATE 2019-08-14				
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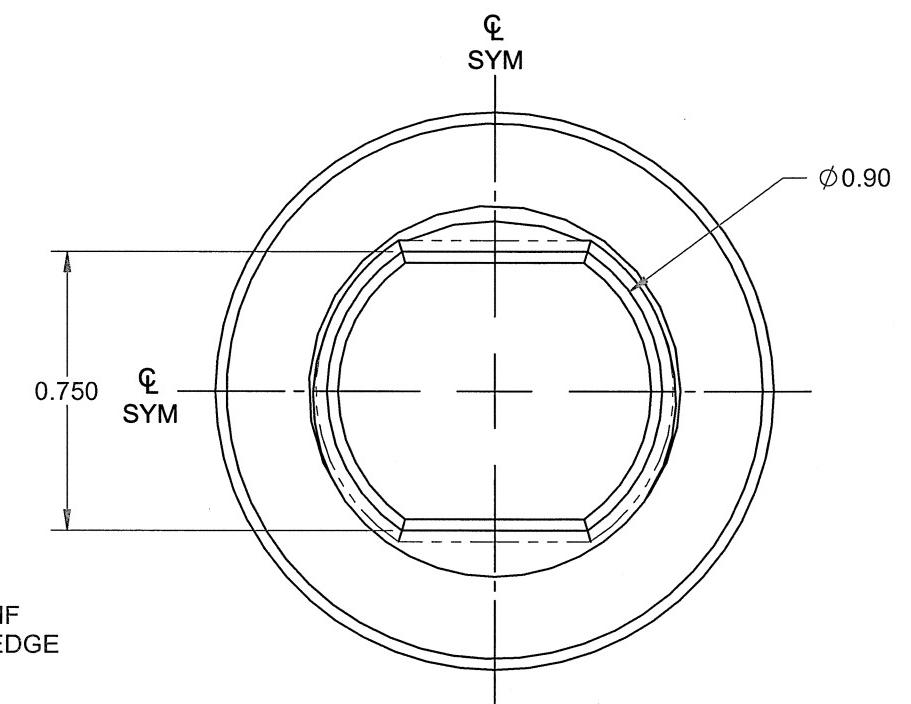
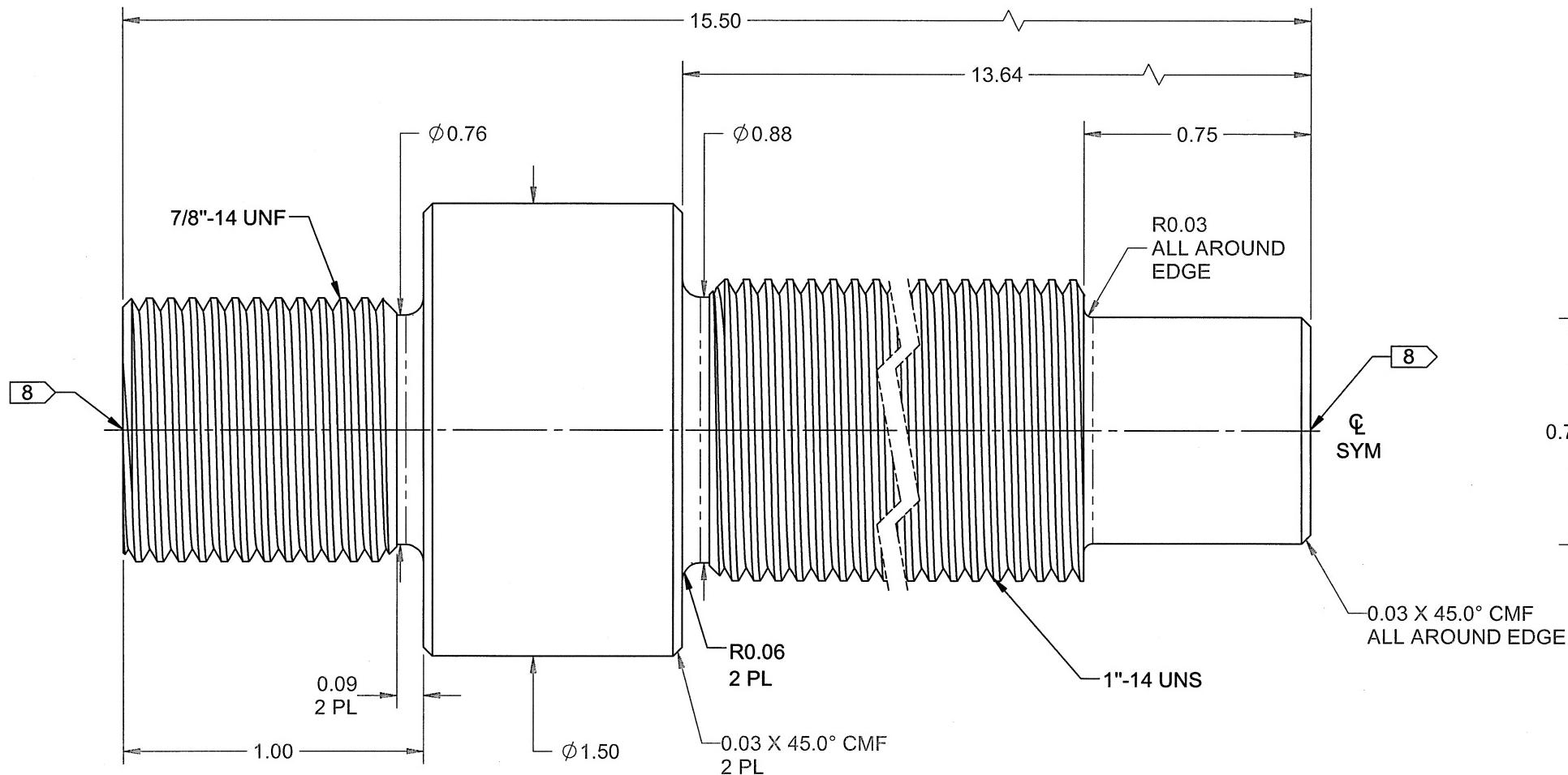
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RBT18526-1 THREADED PULLER ROD

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	
MFG. APPR.	FK	TOOL PART #
APPROVED	WJ	RBT18526
		TITLE
		M/R BLADE BOLT EXTRACTOR
		SCALE NTS
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DATE 2019-08-14

REV C
SHEET 2 OF 5

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ITEM #	QTY	PART #	PART TITLE
-4	1	RBT18526-4	BEARING PLATE
-5	1	RBT18526-5	TUBE

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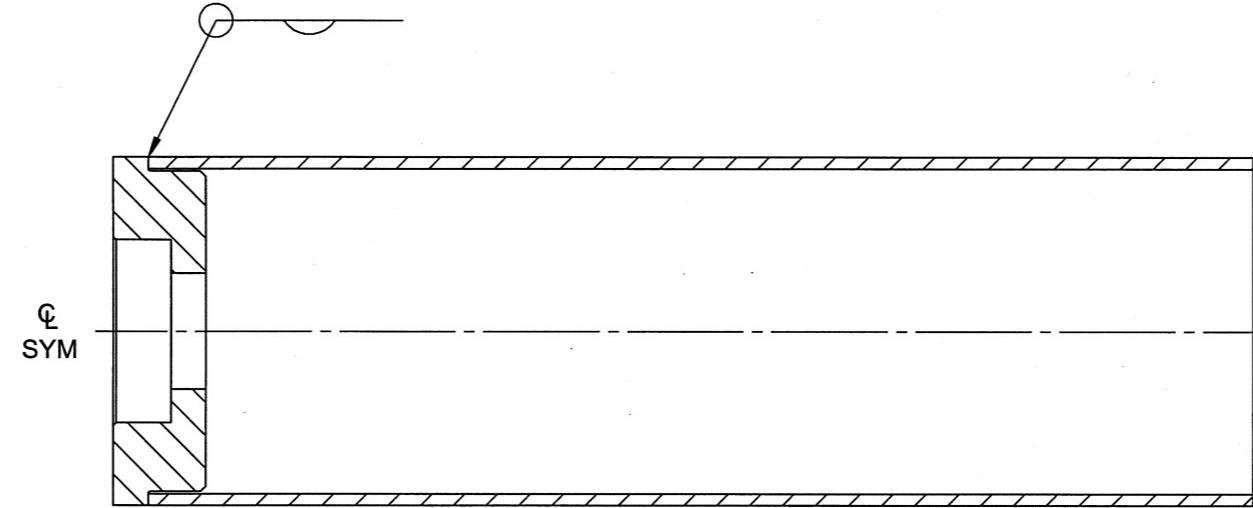
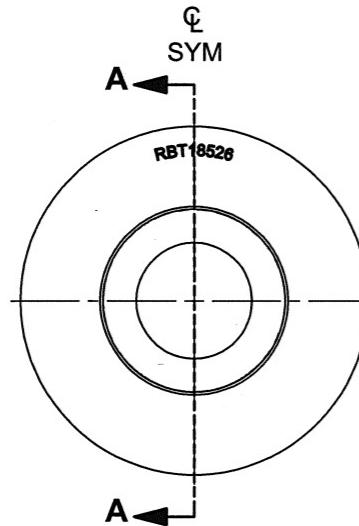
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**SECTION A-A****RBT18526-4A TUBE WELDMENT****NOTES:**

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL WELD SPATTERS

DESIGN	VM
DRAWN	VM
CHECKED	KPT
MFG. APPR.	FK
APPROVED	VJF

DATE 2019-08-14

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART # RBT18526
TITLE M/R BLADE BOLT EXTRACTOR
SCALE NTS

REV C
SHEET 3 OF 5

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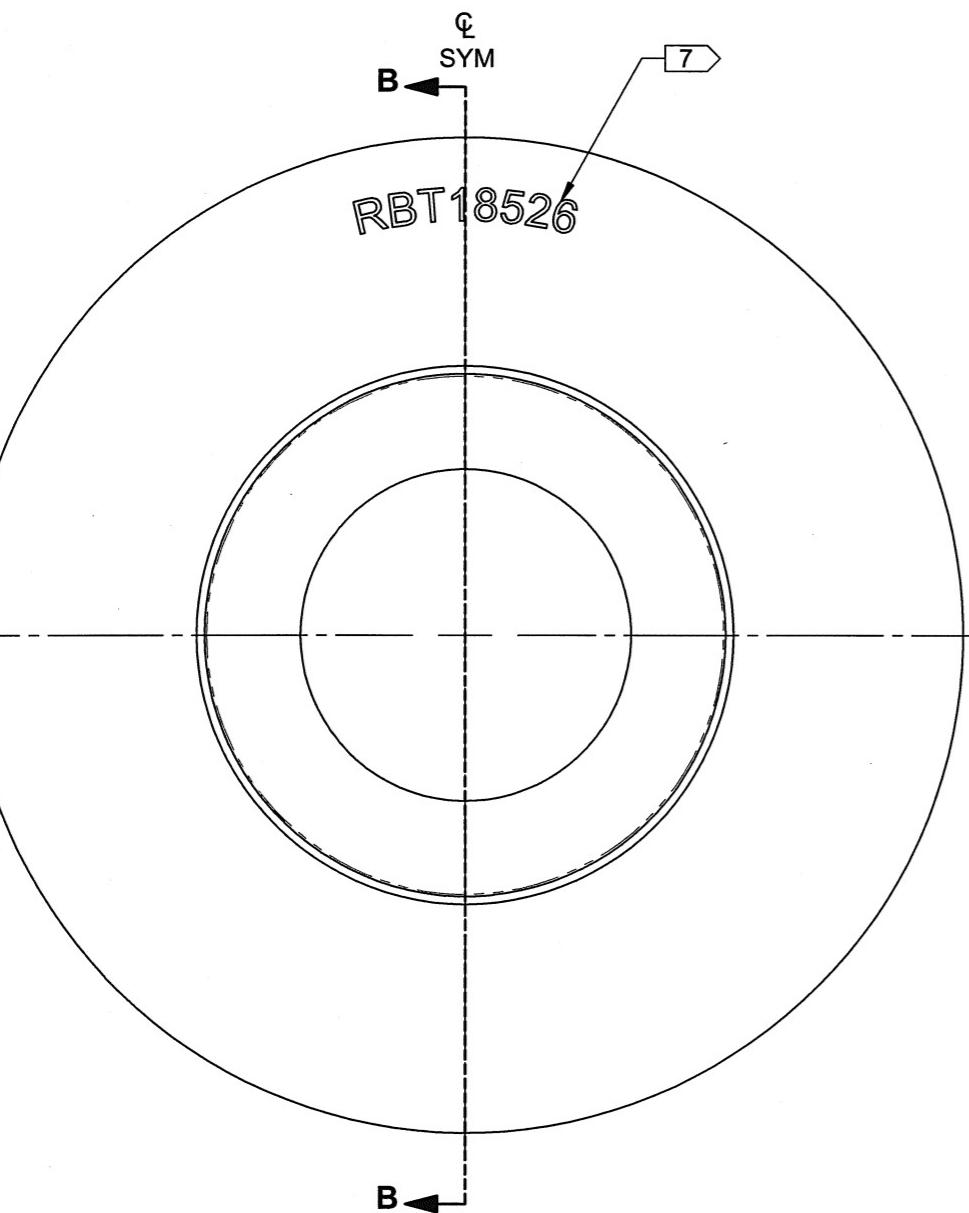
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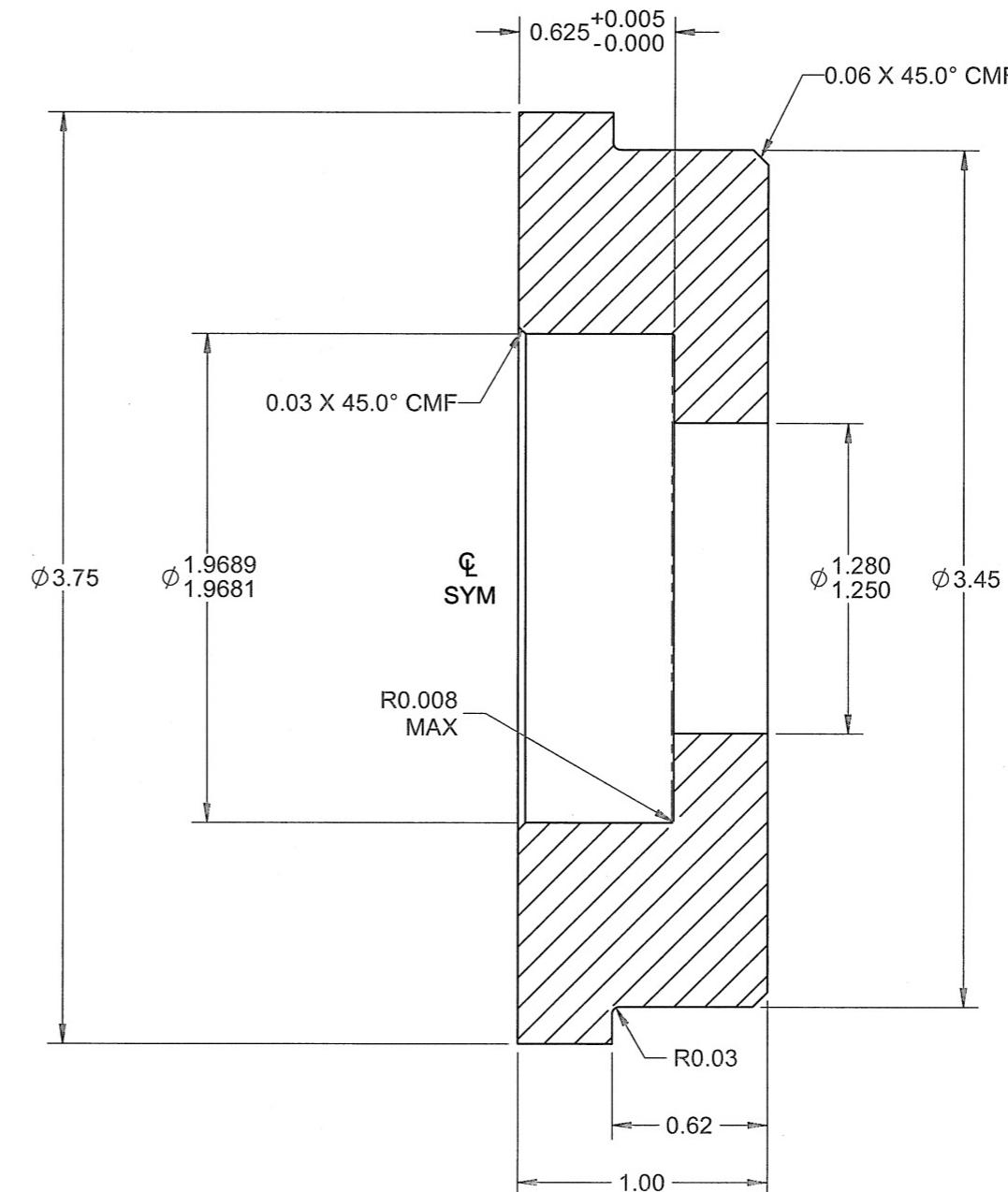
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RBT18526-4 BEARING PLATE



SECTION B-B

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBT18526", AS SHOWN

DESIGN DRAWN	VM	DART AEROSPACE LTD	
CHECKED	KPT	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	FK	TOOL PART #	RBT18526
APPROVED	<i>[Signature]</i>	TITLE	M/R BLADE BOLT EXTRACTOR
DATE 2019-08-14		SCALE	NTS
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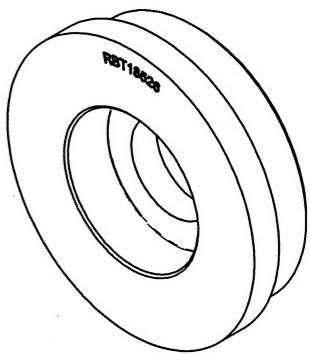
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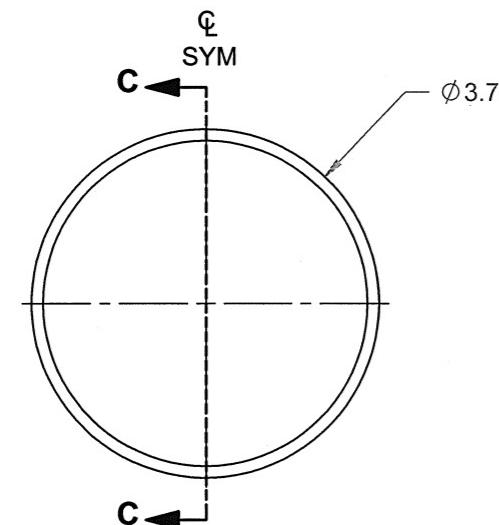
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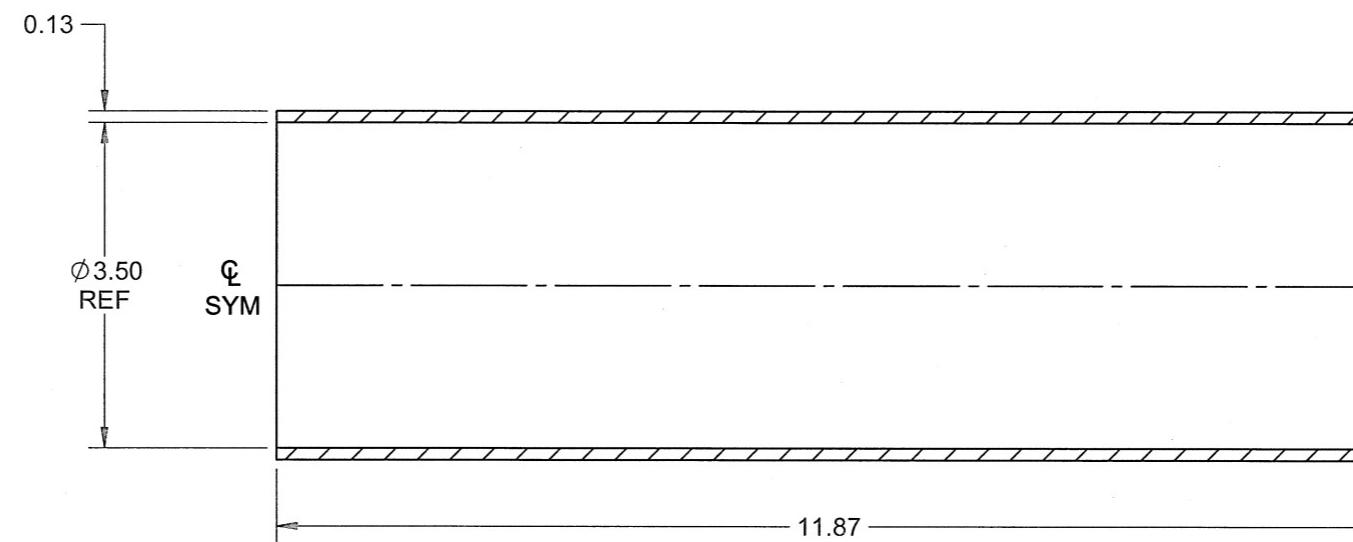
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RBT18526-5 TUBE



SECTION C-C

NOTES:

- 1) MATERIAL: A513 TYPE 5 DOM TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $+\/- 0.1"$ / $+\/- 1^{\circ}$
X.XX = $+\/- 0.01"$ / $+\/- 0.5^{\circ}$
X.XXX = $+\/- 0.005"$ / $+\/- 0.1^{\circ}$
X.XXXX = $+\/- 0.0005"$ / $+\/- 0.05^{\circ}$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+\/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	REV C
MFG. APPR.	FK	SHEET 5 OF 5
APPROVED	WL	
DATE 2019-08-14		

TOOL PART # **RBT18526**

TITLE **M/R BLADE BOLT EXTRACTOR**

SCALE **NTS**

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